



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3065-5

Job Sheet 170994



Part No: D3065-5

Job Qty: 80 ea

Part Name: Step Leg



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/25/18

Job Tracking No:

Due Date: 2/6/18

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG REV B IPP: C 02.11.01 Incorporated D3066-1 IPP KJ/RF IPP Rev:D Now on Water Jet 06-04-11 JLM
IPP Rev:E Now manufactured with 6061-T6 06-05-25 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	100 Ea	2/5/18	2/5/18	0.00	0.00	Start Up Waterjet		5-18/01/30
100	Waterjet	100 pcs	2/5/18	2/5/18	0.02	9.22	Waterjet1		5-18/01/30
120	QC	100 pcs	2/5/18	2/5/18	0.00	0.00	QC8		5-18/01/30
130	HandFinish	100 pcs	2/6/18	2/6/18	0.00	2.26	HandFinish1		18-01-01
140	QC	100 pcs	2/6/18	2/6/18	0.00	0.00	QC7-1		38
150	Packaging	100 pcs	2/6/18	2/6/18	0.00	0.00	Packaging3		9-88
160	QC21-SA	100 Ea	2/6/18	2/6/18	0.00	0.00	QC21		522

Part Op 100 - 1-Cut as per Dwg
Descriptions: 150 - LOCATION : GA

DAS
21
9-88

FEB 05 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.080	6061-T6 .080 Sheet	82.5000 sf (.825 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6S.080	83	181	0

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>			Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																													
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OTHER : _____																																																																

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Step Log	16.458inches ± 0.010	16.468 16.448		
2	Step Log	15.750inches ± 0.005	15.755 15.745		
3	Step Log	2.250inches ± 0.005	2.255 2.245		
4	Step Log	3.460inches ± 0.005	3.465 3.455		
5	Step Log	0.865inches ± 0.005	0.870 0.860		
6	Step Log	6.020inches ± 0.005	6.025 6.015		
7	Step Log	1.205inches ± 0.005	1.210 1.200		
8	Step Log	3.484inches ± 0.005	3.489 3.479		
9	Step Log	0.871inches ± 0.005	0.876 0.866		
10	Step Log	8.325inches ± 0.010	8.335 8.315		
11	Step Log	0.551inches ± 0.010	0.561 0.541		
12	Step Log	0.213inches + 0.005 - 0.000	0.218 0.213		
13	Step Log	0.128inches + 0.005 - 0.000	0.133 0.128		

Plex 1/25/18 12:21 PM dart.lacelle.linda

DQA: _____ Date: _____



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Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
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OTHER : ☐					

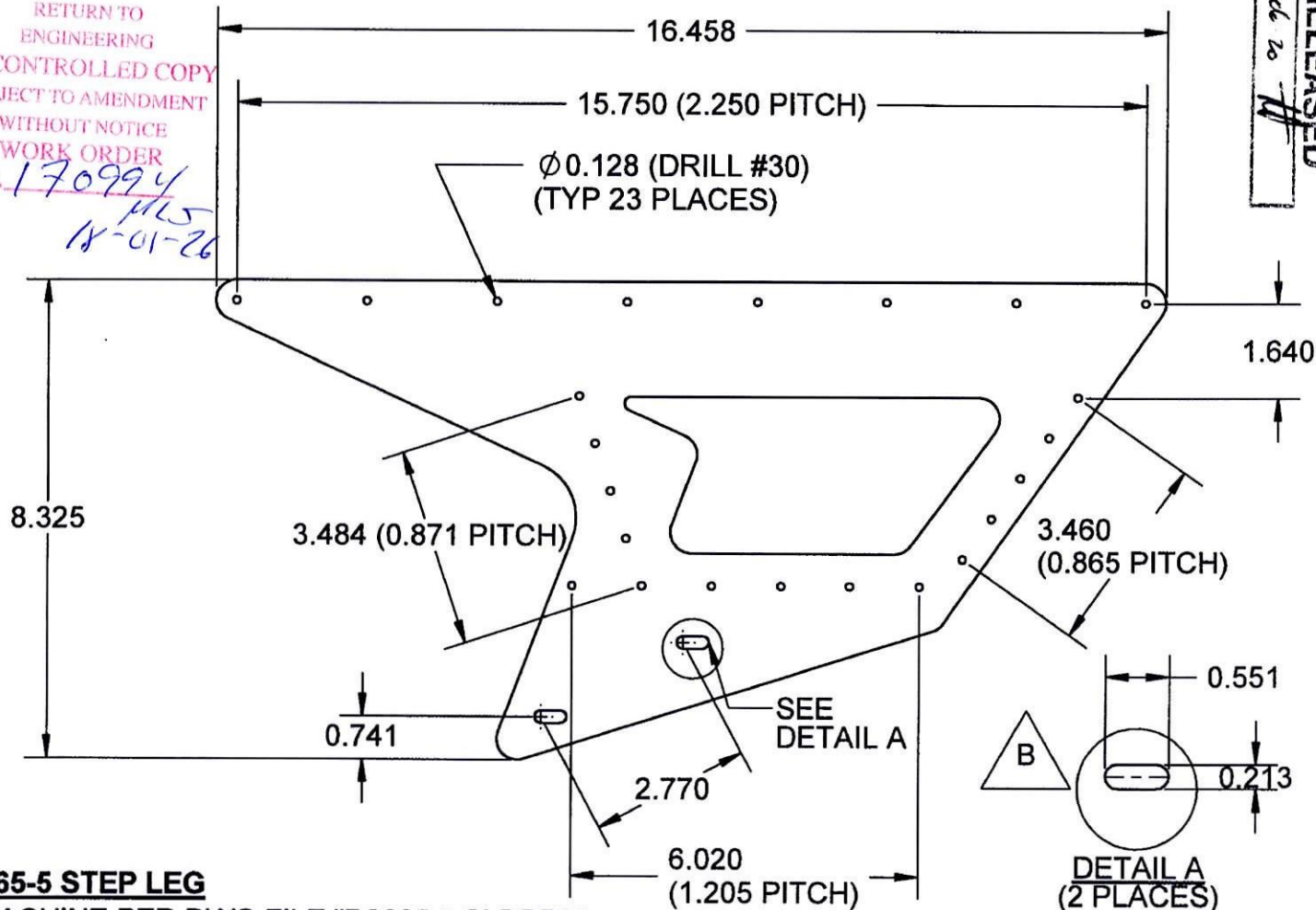
DART

DESIGN	<i>CP</i>	DRAWN BY	<i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>PH</i>	APPROVED	<i>PH</i>	DRAWING NO. D3065
DATE	06.05.23	TITLE	STEP LEG ASSEMBLY	REV. B SHEET 4 OF 5
		SCALE	1:3	

RELEASED

06.06.20

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *170994*
PLS
18-01-26



D3065-5 STEP LEG

- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
- 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK
(REF DART SPEC M6061T6S.080)
OR
5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES